

# Work Order ID 62496

Thursday, September 30, 2010 1:49:40 PM



Page 1

Item ID: PB67-43001-27

Accept



Setup Start



Revision ID:

Item Name: Blade Positioner

Stop



Start Date: 10/1/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: mf

Date: 10-9-30 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

B67-43001-27

Rev C

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1- slide -289, -291 and -293 on -19 tube then slide it in -285 tube □2- drill holes  
0.159 (#21) thru -285 into -289 in (3) place and tap 10-32 UNF as per dwg □3-  
assemble all parts as per dwg PB67-43001

*Handwritten: 10.10.13*

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*Handwritten: 10.10.14*



120

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

*Handwritten: Ppp 63058*

*Handwritten: 10/10/2014*

*Handwritten: 10/10/2014*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 62496**

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Item ID: PB67-43001-27

Accept

Revision ID:

Item Name: Blade Positioner

Start Date: 10/1/2010 Start Qty: 1.00

Required Date: 10/15/2010 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start  
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/20

mf

10-10-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

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Work Order ID: 62496

Parent Item: PB67-43001-27

Parent Item Name: Blade Positioner

Start Date: 10/1/2010


Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00


Comments: IPP Rev:A 08-07-29 new issue DD verified by:ec  
IPP Rev:B 08-12-04 up date part list DD Verified by:ec IPP Rev  
C 10.09.28 per rev C dwg EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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PB67-43001-19		Manufactured	No			100	Each	1.0000	1	1			
													
Inner Tube and Retainer Bushing													

Location Loc Qty Loc Code


ST 1

PB67-43001-29		Manufactured	No			100	Each	0.0000	1	1			
													
Blade Positioner Weldment													


62114 1

100 Each 0.0000 1

362118 345032

PB67-43001-31		Manufactured	No			100	Each	0.0000	1	1			
													
Upper Restraint Weldment													


353335

PB67-43001-35		Manufactured	No			100	Each	6.0000	1	1			
													
Lower Pad Assembly													

Location Loc Qty Loc Code

ST443 6

45030 6

PB67-43001-285		Manufactured	No			100	Each	1.0000	1	1			
													
Upper Tube, Blade Positioner													

Location Loc Qty Loc Code

ST446 1

52670 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 62496

Parent Item: PB67-43001-27

Parent Item Name: Blade Positioner

Start Date: 10/1/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

PB67-43001-289 Manufactured No

100

Each

5.0000

1

1



Stationary Handle Adjustment Fitting



10.10.13

LocationLoc QtyLoc Code

ST439

5

62117

5

PB67-43001-291 Manufactured No

100

Each

4.0000

1

1



Clamp Bushing



10.10.13

LocationLoc QtyLoc Code

ST439A

4

62121

4

PB67-43001-293 Manufactured No

100

Each

14.0000

1

1



Extension Tube Adjustment Fitting



10.10.13

LocationLoc QtyLoc Code

ST439A

14

41882

7

47365

7

AN6-22A Purchased No

100

Each

27.0000

1

1



BOLT



10.10.13

LocationLoc QtyLoc Code

ST342

27

110155

7

111060

20

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID: 62496

Parent Item: PB67-43001-27



Parent Item Name: Blade Positioner

Start Date: 10/1/2010



Required Date: 10/15/2010

Start Qty: 1.00



Required Qty: 1.00

MS21042L6 Purchased No 100 Each 256.0000 1 1  
  
 Nut  10.10.13



Location	Loc Qty	Loc Code
ST300	256	
111578	4	
<u>114495</u>	52	
115300	200	

MS27039-1-04 Purchased No 100 Each 353.0000 3 3  
  
 SCREW  10.10.13

Location	Loc Qty	Loc Code
ST291	353	
<u>115006</u>	353	

MS27039-1-08 Purchased No 100 Each 1,589.000 1 1  
  
 Screw  10.10.13

Location	Loc Qty	Loc Code
ST291	1589	
110835	477	
114718	112	
<u>115108</u>	1000	

MS27039-1-09 Purchased No 100 Each 385.0000 6 6  
  
 Screw  10.10.13

Location	Loc Qty	Loc Code
ST291	385	
111650	356	
<u>18057</u>	29	

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W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 62496

Parent Item: PB67-43001-27



Parent Item Name: Blade Positioner

Start Date: 10/1/2010

Required Date: 10/15/2010

Start Qty: 1.00



Required Qty: 1.00

MS51859-8 Purchased No 100 Each 63.0000 2 2  
  
 WASHER  10.10.13

Location Loc Qty Loc Code

ST296 63

112940 63

NAS1149F0316P Purchased No 100 Each 287.0000 7 7  
  
 WASHER  10.10.13



Location Loc Qty Loc Code

ST275 287

112940 87

113237 100

113644 100



NAS1149F0363P Purchased No 100 Each 169.0000 3 3  
  
 Washer  10.10.13

Location Loc Qty Loc Code

ST275 169

113254 69

114382 100

NAS1149F0632P Purchased No 100 Each 481.0000 2 2  
  
 WASHER  10.10.13

Location Loc Qty Loc Code

ST275 481

18057 481

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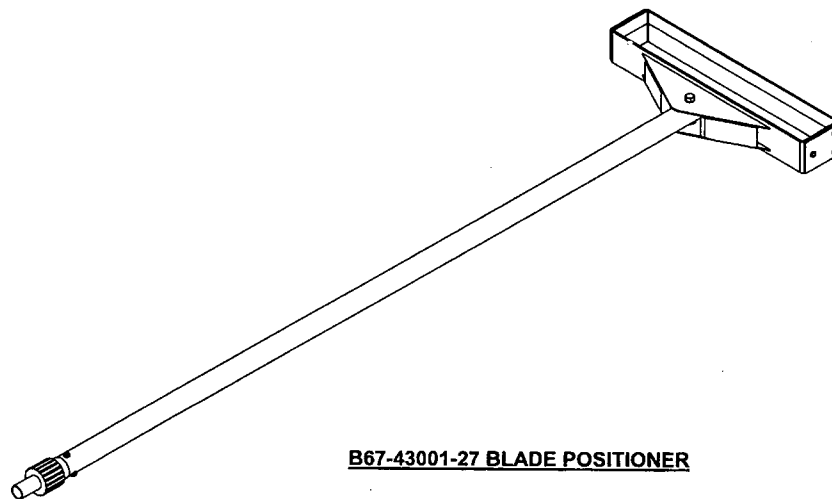
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**B67-43001-27 BLADE POSITIONER**

#62496

**NOTES:**

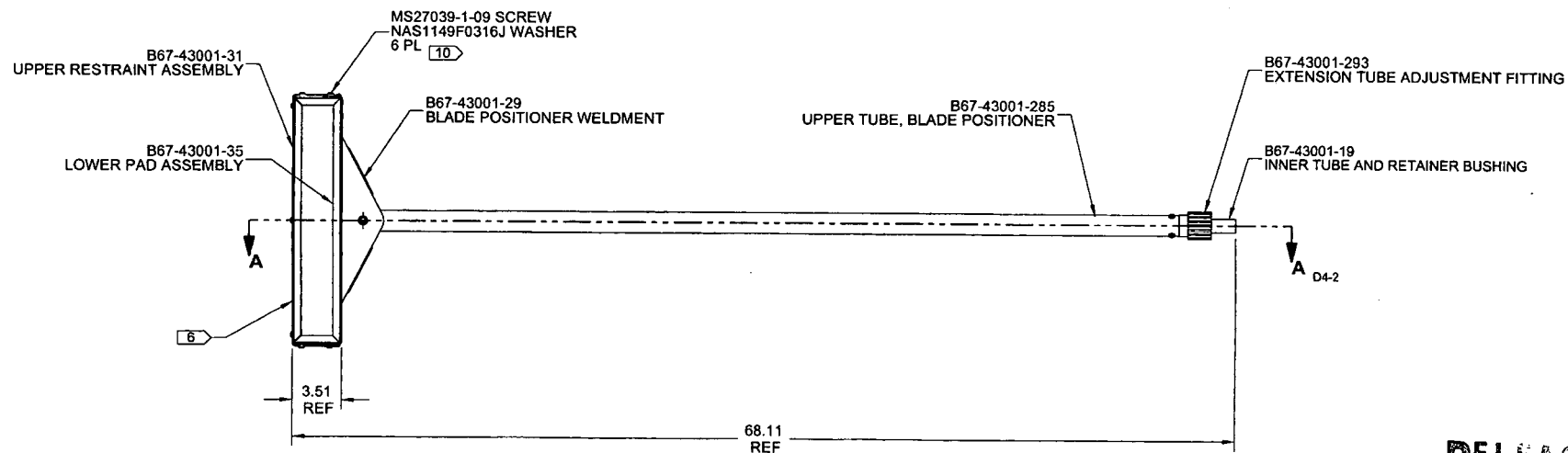
- 1) MATERIAL: NONE
- 2) FINISH: TOUCH UP PAINT WITH SANDFLEX GREEN.  
POSSIBLE SUPPLIER BERTRAND BODY SHOP SUPPLIES P/N DART01K
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH RED LABEL
- 7) WEIGHT: 7.07 lbs
- 8) DRILL THRU B67-43001-285/-289 PRIOR TO ASSEMBLY
- 9) DO NOT TORQUE NUT ON BOLT: TIGHTEN UNTIL SNUG
- 10) MATCH DRILL  $\varnothing 0.193$  HOLE THRU B67-43001-29 WITH NUTPLATES LOCATED ON B67-43001-35

ITEM	QTY. -27	P/N	DESCRIPTION
	X	B67-43001-27	BLADE POSITIONER
1	1	B67-43001-19	INNER TUBE AND RETAINER BUSHING
2	1	B67-43001-29	BLADE POSITIONER WELDMENT
3	1	B67-43001-31	UPPER RESTRAINT ASSEMBLY
4	1	B67-43001-35	LOWER PAD ASSEMBLY
5	1	B67-43001-285	UPPER TUBE, BLADE POSITIONER
6	1	B67-43001-289	STATIONARY HANDLE ADJUSTMENT FITTING
7	1	B67-43001-291	CLAMP BUSHING
8	1	B67-43001-293	EXTENSION TUBE ADJUSTMENT FITTING
9	1	AN6-22A	BOLT
10	1	MS21042L6	NUT
11	3	MS27039-1-04	SCREW
12	1	MS27039-1-08	SCREW
13	6	MS27039-1-09	SCREW
14	2	MS51859-8	WASHER
15	7	NAS1149F0316P	WASHER
16	3	NAS1149F0363P	WASHER
17	2	NAS1149F0632P	WASHER

**RELEASED**  
R 2010-09-21  
JM

C		REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 4 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		VS	10.06.10
REV.	DESCRIPTION			BY	DATE
DESIGN	RW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		REV. C	SHEET 1 OF 3
DRAWN	VS				
CHECKED	VS	DRAWING NO.		TITLE	
MFG. APPR.	VS	B67-43001-27		SCALE	
APPROVED	VS	TITLE		NTS	
DE APPR.	VS	BLADE POSITIONER		NTS	
DATE	10.06.10				
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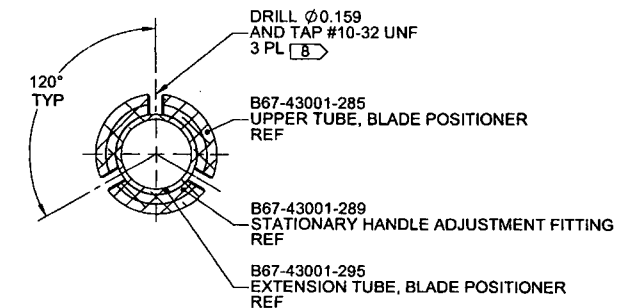
**SECTION A-A B2-2**



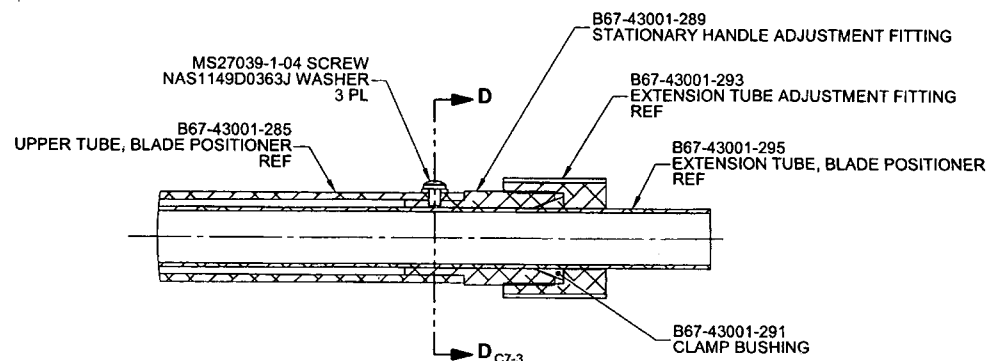
**B67-43001-27 BLADE POSITIONER**

**RELEASED**  
2010-09-21

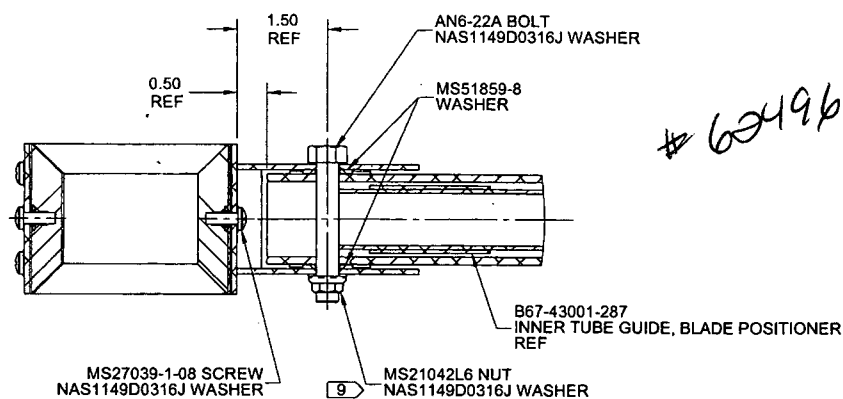
DESIGN	RW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		B67-43001-27	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.	N/A	BLADE POSITIONER	NTS
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**SECTION D-D** C3-3  
(HARDWARE NOT SHOWN FOR CLARITY)



**DETAIL C** D3-2  
SCALE 4X



**DETAIL B** D7-2  
SCALE 4X

**RELEASED**  
2010-09-21

DESIGN	RW	<b>DART AEROSPACE LTD</b>	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		<b>B67-43001-27</b>	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>BLADE POSITIONER</b>	NTS
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